

Date: Friday, 20/02/2009 9:23:51 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)	
Job Number	: 45924		Part Number	: D2574	
Estimate Number	: 10534		Drawing Number	: D2574 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 20/02/2009		Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 27/02/2009	
Previous Run	: 44205		Qty:	20	
Written By	: <i>JLM 09.02.20</i>		Um:	1/2 Each	
Checked & Approved By	:				
Comment	: Est Rev: I As Per RevE 06-01-27 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	Saddle Billet
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B34874</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>45924</u> Double check by: <i>DAT</i>
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 45924

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 09/03/04 (20)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 09-03-4

7.0 POWDER COATING POWDER COATING



M 110439

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 4:00PM

9A 09-03-04 (20)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FOL 09/03/05

(20)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

STY34 PC8/3/6 (20)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

1009/03/08

Job Completion



MF
09-03-08

DART AEROSPACE LTD	Work Order:	45924
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.7500	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.000	8.000		
F	0.490	0.510		.493	.504	.497	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.376		
I	0.490	0.510		.493	.497	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.562	.560	.560	.560		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.135	.131	.135	.135		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.127	.135	.129	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.245	.240	.247	.243		
W	0.115	0.135		.131	.130	.125	.125		
X	0.307	0.312		.312	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.368	.368	.370	.370		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.628	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.508	1.509	1.508	1.508		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.267	.268	.268	.270		
AH	0.240	0.260		.253	.250	.254	.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 8/1
Date: 09/02/26

Audited by: J.F.
Date: 09/12/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JF

DART AEROSPACE LTD

Work Order:

45924

Description: Saddle, Aft Inboard

Part Number:

D2574

Inspection Dwg: D2574 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 X	6 Z	7 Y	8 A	By	Date
A	0.438	0.443		.440	.440	.438	.440		
B	1.745	1.755		1.752	1.748	1.749	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.493	.493	.500	.506		
G	0.257	0.262		.259	.253	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.498	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.571	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.377	1.377	1.377	1.377		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.120	.130	.130	.130		
Q	0.115	0.135		.130	.135	.135	.135		
R	0.240	0.260		.255	.252	.252	.252		
S	0.115	0.135		.130	.130	.125	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.236	3.236	3.236		
V	0.230	0.250		.238	.242	.244	.245		
W	0.115	0.135		.125	.123	.120	.119		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.370	.367	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.623	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.512	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.280	.260	.260	.260		
AH	0.240	0.260		.254	.252	.253	.253		
AI	2.000	2.020		2.000	2.000	2.000	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 88 MNF
 Date: 09/02/27 09/02/28

Audited by: J.F.
 Date: 09/10/2010

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	✓ JLM

DART AEROSPACE LTD	Work Order:	45984
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.000	8.001	8.002	8.001		
F	0.490	0.510		.498	.495	.497	.495		
G	0.257	0.262		.259	.260	.260	.260		
H	0.375	0.380		.376	.375	.375	.375		
I	0.490	0.510		.499	.499	.499	.502		
J	1.174	1.184		1.178	1.177	1.177	1.177		
K	0.558	0.578		.567	.565	.570	.565		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.368	1.368	1.370		
N	2.495	2.505		2.499	2.495	2.497	2.495		
O	4.119	4.129		4.122	4.120	4.121	4.122		
P	0.115	0.135		.128	.128	.130	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.254	.251	.252	.251		
S	0.115	0.135		.125	.125	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.245	.243	.243		
W	0.115	0.135		.121	.125	.125	.125		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.372	.371	.372		
AA	0.470	0.530		.500	.500	.498	.500		
AB	0.615	0.635		.624	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.512	1.500	1.501	1.508		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.268	.270	.270	.270		
AH	0.240	0.260		.252	.255	.251	.251		
AI	2.000	2.020		2.001	2.001	2.002	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	mwt
Date:	07/03/01

Audited by:	J-F.
Date:	09/03/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	45924
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13	14	15	16		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.498	3.499	3.498	3.500		
D	1.745	1.755		1.748	1.747	1.748	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.001		
F	0.490	0.510		.495	.500	.495	.498		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.376	.376	.376	.377		
I	0.490	0.510		.500	.500	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.180		
K	0.558	0.578		.570	.569	.569	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.368	1.369	1.366	1.372		
N	2.495	2.505		2.498	2.497	2.497	2.495		
O	4.119	4.129		4.121	4.120	4.121	4.124		
P	0.115	0.135		.120	.129	.130	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.251		
S	0.115	0.135		.126	.126	.127	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.229	3.230	3.228		
V	0.230	0.250		.241	.244	.246	.244		
W	0.115	0.135		.120	.120	.120	.120		
X	0.307	0.312		.312	.311	.311	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.367	.366	.370		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.508	1.508	1.510	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.266	.253	.255	.265		
AH	0.240	0.260		.250	.252	.252	.252		
AI	2.000	2.020		2.003	2.000	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	09/03/02

Audited by:	<i>J.F.</i>
Date:	09/03/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signatures]</i>

DART AEROSPACE LTD

Work Order: 45924

Description: Saddle, Aft Inboard

Part Number: D2574

Inspection Dwg: D2574 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.000	8.000	8.001	8.001		
F	0.490	0.510		.499	.500	.500	.499		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.748	1.748	1.748	1.748		
K	0.558	0.578		.572	.572	.572	.570		
L	1.174	1.184		1.748	1.748	1.748	1.748		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.494	2.495	2.495	2.494		
O	4.119	4.129		4.128	4.122	4.120	4.122		
P	0.115	0.135		.126	.126	.128	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.252	.251		
S	0.115	0.135		.126	.125	.126	.126		
T	0.178	0.198		.182	.182	.188	.188		
U	3.210	3.250		3.231	3.233	3.233	3.232		
V	0.230	0.250		.247	.247	.248	.249		
W	0.115	0.135		.119	.119	.119	.116		
X	0.307	0.312		.312	.312	.312	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.371	.370	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.624	.624	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.508	1.509	1.510	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.264	.265	.265	.265		
AH	0.240	0.260		.251	.251	.251	.253		
AI	2.000	2.020		2.001	2.001	2.001	2.000		
AJ	0.023	0.043		.032	.033	.033	.033		
Accept/Reject									

Measured by: *mjs*
 Date: 09/03/02

Audited by: J.F. 09/03/02
 Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>df</i>	<i>Sh</i>

